

Work Order ID 72143

Tuesday, July 19, 2011 1:44:40 PM



Page 1

Item ID: D3601-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Radius Block					
Start Date: 7/19/2011	Start Qty: 30.00		Cust Item ID:		
Required Date: 7/25/2011	Req'd Qty: 30.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date: 11-07-19	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3601	Rev A

100		0.00							
	SHEAR								
Shear	Memo	0.00							
Shear	blanks 9.00" long +/- 0.030" □ Note: 1 blank makes 8 pieces								

ml 11/08/18

32 - P

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA682 Rev: <u>AA</u> & Dwg D3601 Rev: <u>A</u>								

ml / FK - 11/08/19

32 - P

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

ml / FK - 11/08/19

32 - P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3601-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Radius Block

Start Date: 7/19/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

11-08-22

Memo

0.00

32

140



Small Fab

Small Fab

Small Fab

Memo

1-Tumble

2-Deburr any rough edges after tumbling

0.00

0.00

11/08/22

32

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

32^x M 11/08/24

W/O:		WORK ORDER CHANGES					
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Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				32	BR	11-8-24	
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>ST 69</u> Memo	0.00 0.00	SP			SP	11-08-24		
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/8/24	

11-08-24
32

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Picklist Print

Tuesday, July 19, 2011 1:44:47 PM

Page 1

Work Order ID: 72143



Parent Item: D3601-1



Parent Item Name: Radius Block

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 07-03-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No				f	85.7500		1.998			



6061-T6 Bar .750 x .125

Location

Loc Qty

Loc Code

MAT001

85.75

116406

2.75

116700

23

117653

60

2.00 *ml 7/10/18*

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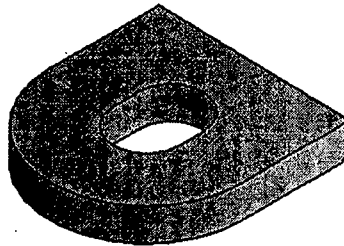
NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3601	REV. A SHEET 1 OF 1
DATE 07.02.13	TITLE RADIUS BLOCK		SCALE 2:1
REV A	DATE 07.02.13	DESCRIPTION NEW ISSUE	

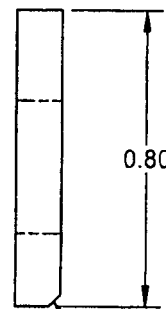
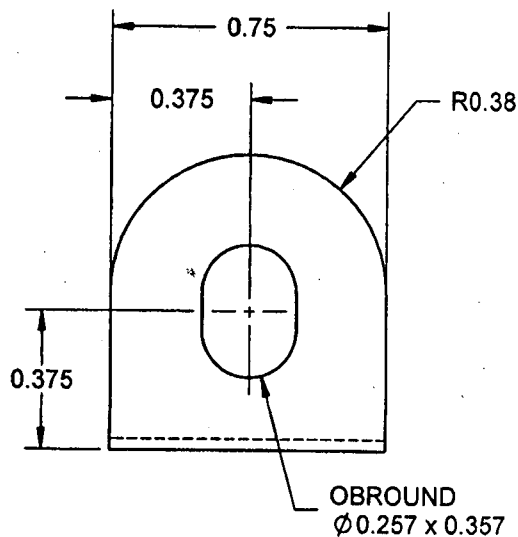
RELEASED

07.03.08



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72143

11-07-19



CHAMFER 0.05
0.03 x 45° OR
FILLET R 0.05
0.03

D3601-1 RADIUS BLOCK**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 SHEET, 0.125 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.125) OR ALUMINUM 6061-T6 SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3601-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.050 MAX

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